

Date: Monday, 18/08/2008 3:30:40 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X24")
Job Number : 41313	
Estimate Number : 10972	
P.O. Number :	Part Number : D130700011
This Issue : 18/08/2008 S.O. No. :	Drawing Number : D3167 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 38142	Material :
Written By :	Due Date : 10/09/2008 Qty: 4 Um: Each
Checked & Approved By : JLD 08.8.18	
Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 08-01-09 Added Step 2 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.8.28

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D130-700-011CHG001

609/10/15

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------

**Comment:** MFG ENGINEERING

Program Batch Number

JLD 08.09.19

3.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 7.1610 sf(s)/Unit Total: 28.6440 sf(s)

blank: 20.00" x 24.00" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"

(MUHMWB10)

Batch: M109497 X 6

M109013 X 2

N.A 08/10/07

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA285 and Dwg D3167

3-Deburr

20 08/10/14
N.A 08/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:30:40 PM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/10/14

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

LF 08/10/15 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

8.0

D2182B

Rubber Cushion



Comment: Qty.: 2.0000 f(s)/Unit Total : 8.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B060 Rubber Cushion

B 39986

CUT 6.00" LONG

9.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

41422

2 D2432F(ref only)

Bearpaw

41313

10.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2519

Clamp

41430

Handwritten notes and signatures for Seq. # 10.0, including a circled '4' and a signature.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 41313

Part Number: D130700011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer 41431

12.0

D31711

Angle



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D3171-1 Angle 38176

13.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-12A Bolt 1108672

14.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt 1108868

15.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer 1108827

8/14/15 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:30:40 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 41313

Part Number: D130700011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M108/45

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-700-011

Location: A

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41313
Description: Bearpaw		Part Number: D3167-1
Inspection Dwg: D3167	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	.06 x 45			
B	5.80	+/-0.030	5.60			
C	0.25 x 45°	+/-0.030	.25 x 45°			
D	R0.25	+/-0.030	.25			
E	0.200	+/-0.030	.200			
F	0.250	+/-0.010	.250			
G	0.625	+/-0.030	.625			
H	0.375	+/-0.010	.375			
I	0.950	+0.030/-0.010	.950			
J	3.21	+/-0.030	3.21			
K	19.00	+/-0.030	19.00			
L	Ø0.260	+0.005/-0.000	.260			
M	Ø0.93	+/-0.030	.93			
N	0.30	+0.030/-0.000	.30			
O	0.375	+/-0.030	.375			
P	7.23	+/-0.030	7.23			
Q	4.54	+/-0.010	4.54			
R	2.00	+/-0.030	2.00			
S	12.000	+/-0.010	12.000			
T	6.000	+/-0.010	6.000			
U	23.75	+/-0.030	23.75			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/10/14	Date: 08/10/15	Date:	N/A

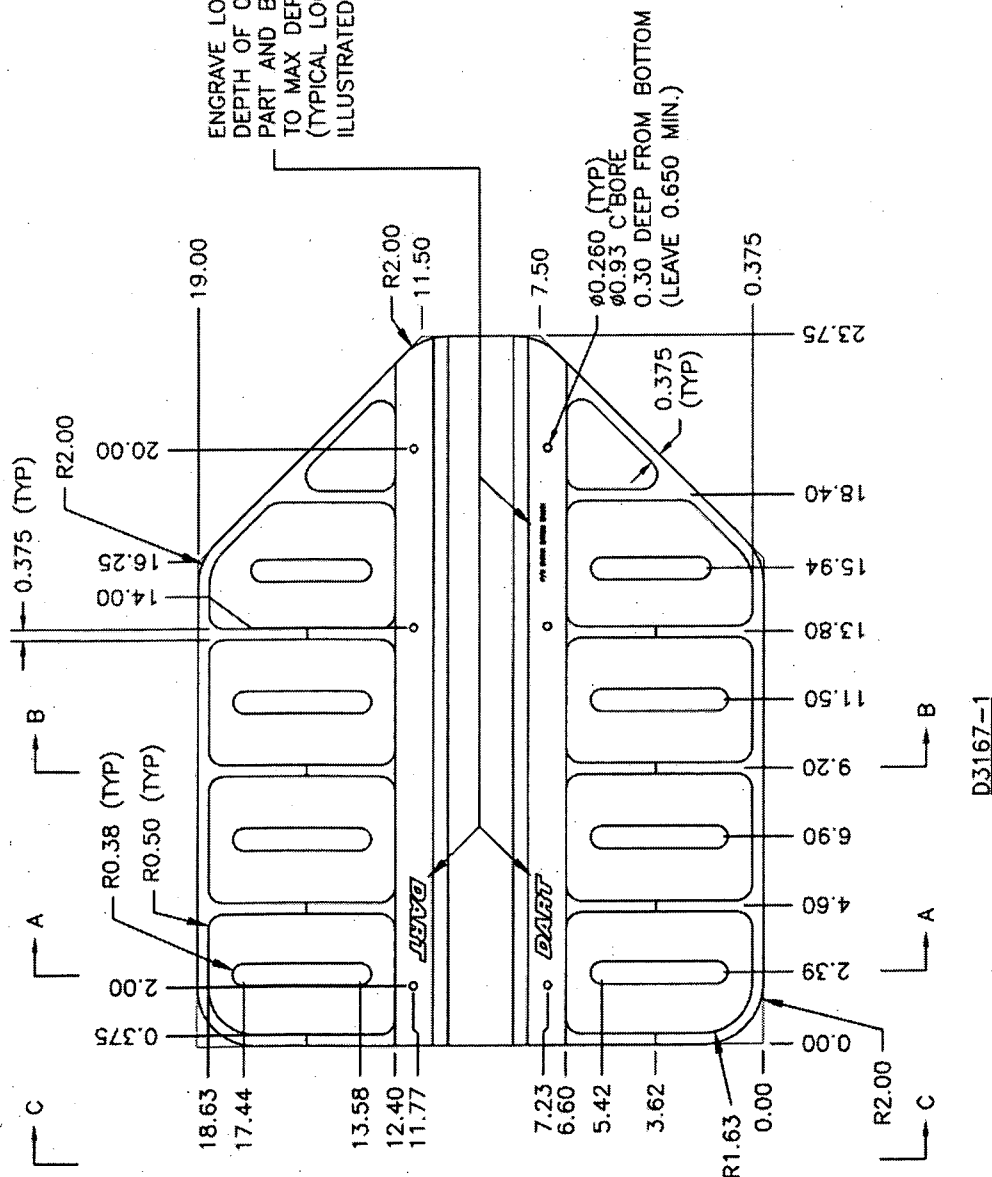
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF [Signature]	[Signature]



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3167	REV. A SHEET 1 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:6
A	02.10.08	NEW ISSUE	
AI	02.12.17	5.80 WAS 5.50	

RELEASED
02.10.25

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



MAX. MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
DIMENSIONS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41313

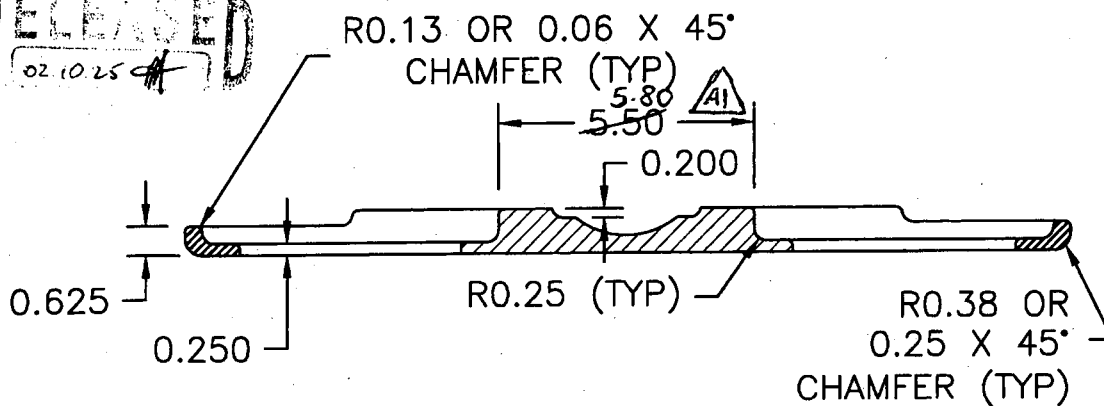
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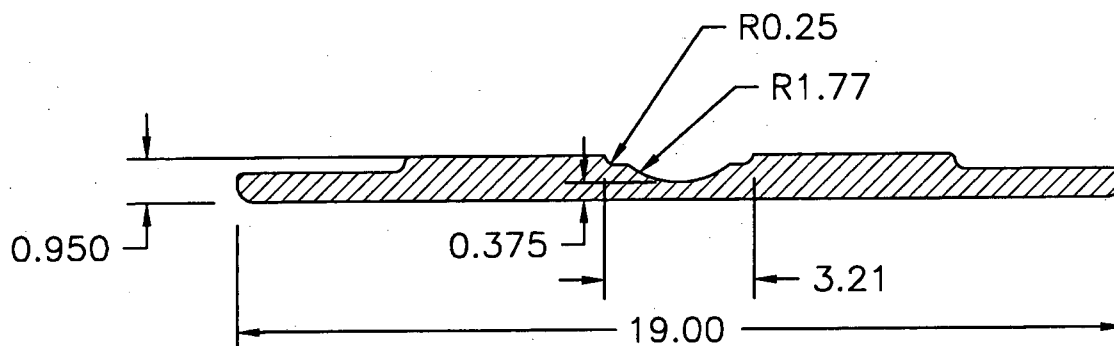
DART

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CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08	TITLE BEARPAW		SCALE 1:4

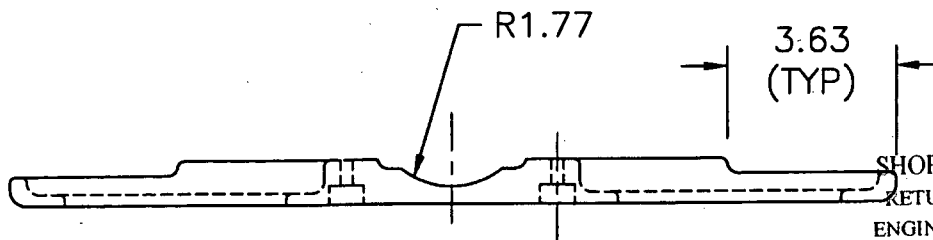
RELEASED
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4313

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